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(54) **MANUFACTURE OF POLYESTER BOTTLE**

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(57) Abstract

**PURPOSE:** To improve the bottom moldability of the bottle constricted at the middle part thereof in a biaxial orientation blow molding method, by defining the ratio of the shortest length to the longest length of the cross section of the tip of an orientation rod at a certain relationship, and making the cross sectional dimensions of the rod smaller than those of the constricted part of the bottle.

**CONSTITUTION:** At a temperature range where polyester can be stretched, the PET parison 1 is stretched longitudinally by an orientation rod 3 and laterally by a pressure rod to effect the biaxial orientation blow molding to obtain the bottle constricted at the middle part thereof. In this case, as the orientation rod 3 has the following specified configuration, the risk is obviated which will break the bottom of the preform by the tip thereof. The ratio of the shortest length (a) to the longest length (b) of the cross section of the tip of the orientation rod is  $(b)/(a) \leq 2$ , and the cross sectional configuration of the rod is smaller than that of the constricted part of the bottle.

